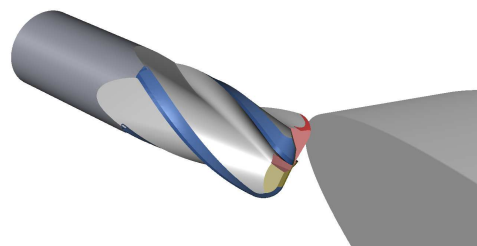
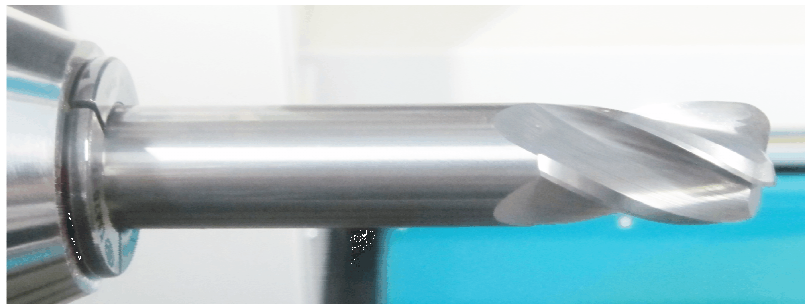


Endmill Ø14 Z4 R3

A01-112

For the radius endmill, the gashing operation can be subdivided into 2 parts. The radius part of it follows properly the radius and generates a cutting edge correction.



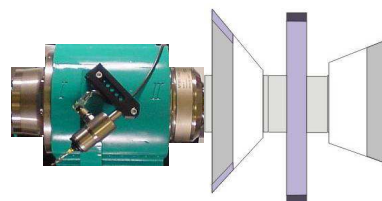
1. Cycletime for Production

Workpiece: Ø 14 mm, Z 4, Length 26 mm, Helix angle 30°, radius 3 mm Material CARBIDE									
Operations	Probe	Flute 1	Gash straight	Gash Rad.	End 2	End 1	End 3	Rad - O.D. 1	Rad - O.D. 2
Feed [mm/Min]	2000	80	80	260	60	100	70	250	350
Power [kW]		3	2	1	1	1	2	1	1
Cutting speed [m/s]		20	22	22	22	22	22	22	22
Used wheels		1	2	2	3	3	3	3	3
Grinding time [s]	12	132	54	24	52	36	51	203	150
Total cycle time	11 Min 56								

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64



2 1 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG Coolant: Synthetic Oil, pressure 6 bar
 Control: Fanuc 31iA5 Software: Quinto 5
 Accessories:

Responsible engineer: OP. 29.5.12

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